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(54) **DUPLEX LINERS AND METHODS OF MAKING AND USING SAME**

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**B31D 1/00** (2017.01)  
**B31D 1/02** (2006.01)

(52) **U.S. Cl.**  
CPC ..... **B31D 1/021** (2013.01); **B31D 1/027** (2013.01)

(58) **Field of Classification Search**  
CPC . B31D 1/00; B31D 1/02; B31D 1/021; B31D 1/027

See application file for complete search history.

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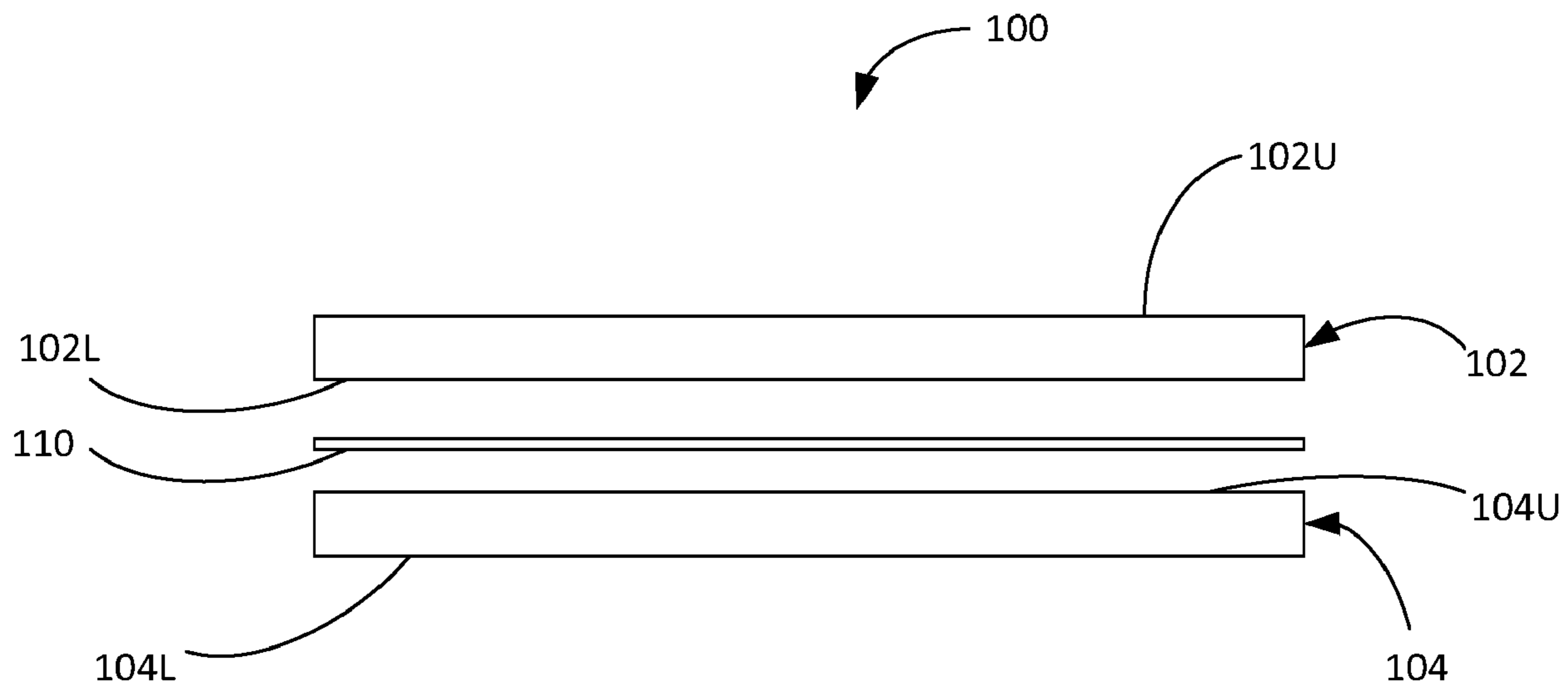
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(57) **ABSTRACT**

A duplex liner for a label. A method for making a label comprises providing a printable face ply. The method comprises making a duplex liner by: (a) providing a transparent first liner ply; (b) providing a second liner ply that is configured to be printable; and (c) using a binder to bind the first liner ply to the second liner ply. The method includes releasably securing the duplex liner to the printable face ply.

**20 Claims, 4 Drawing Sheets**



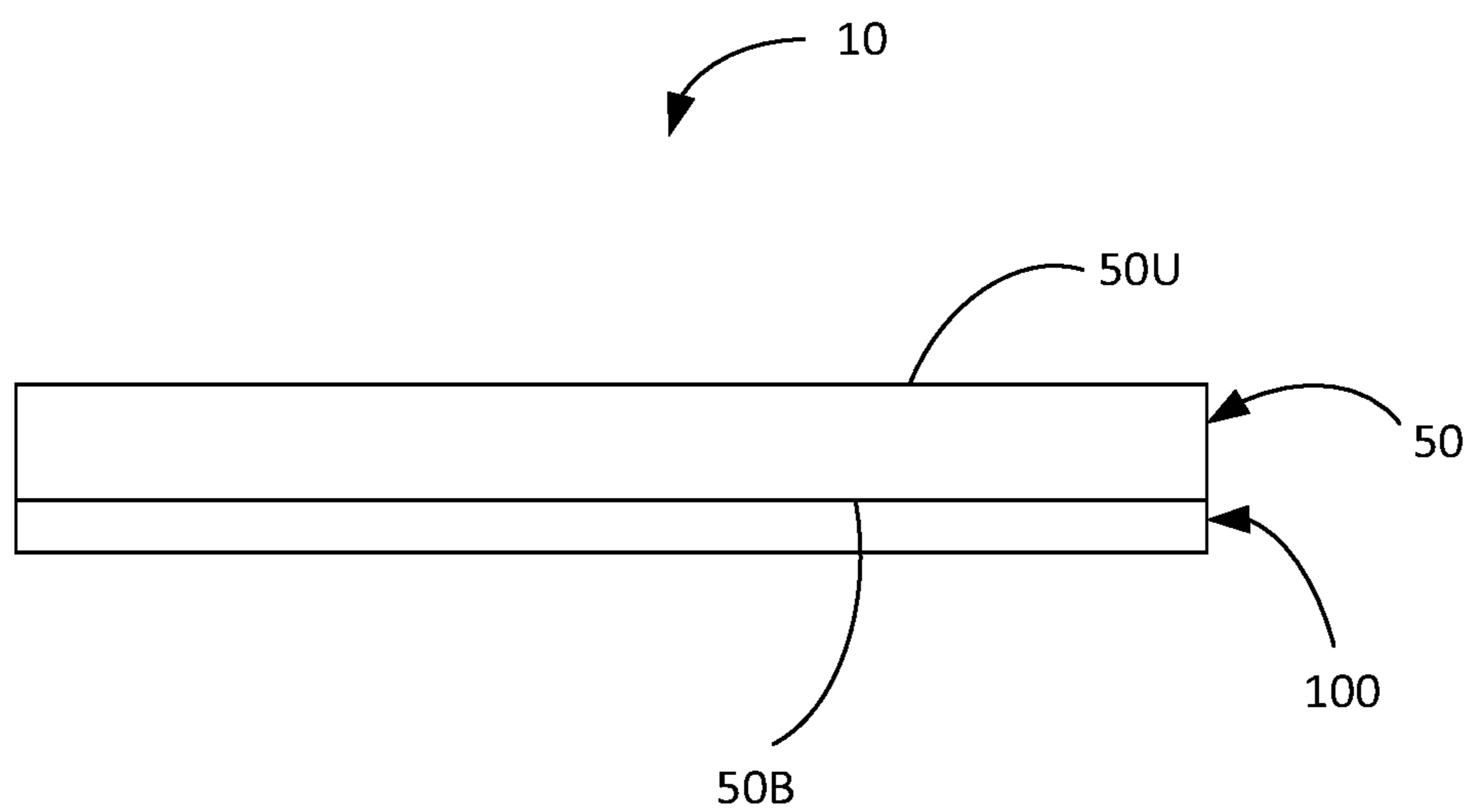


FIGURE 1

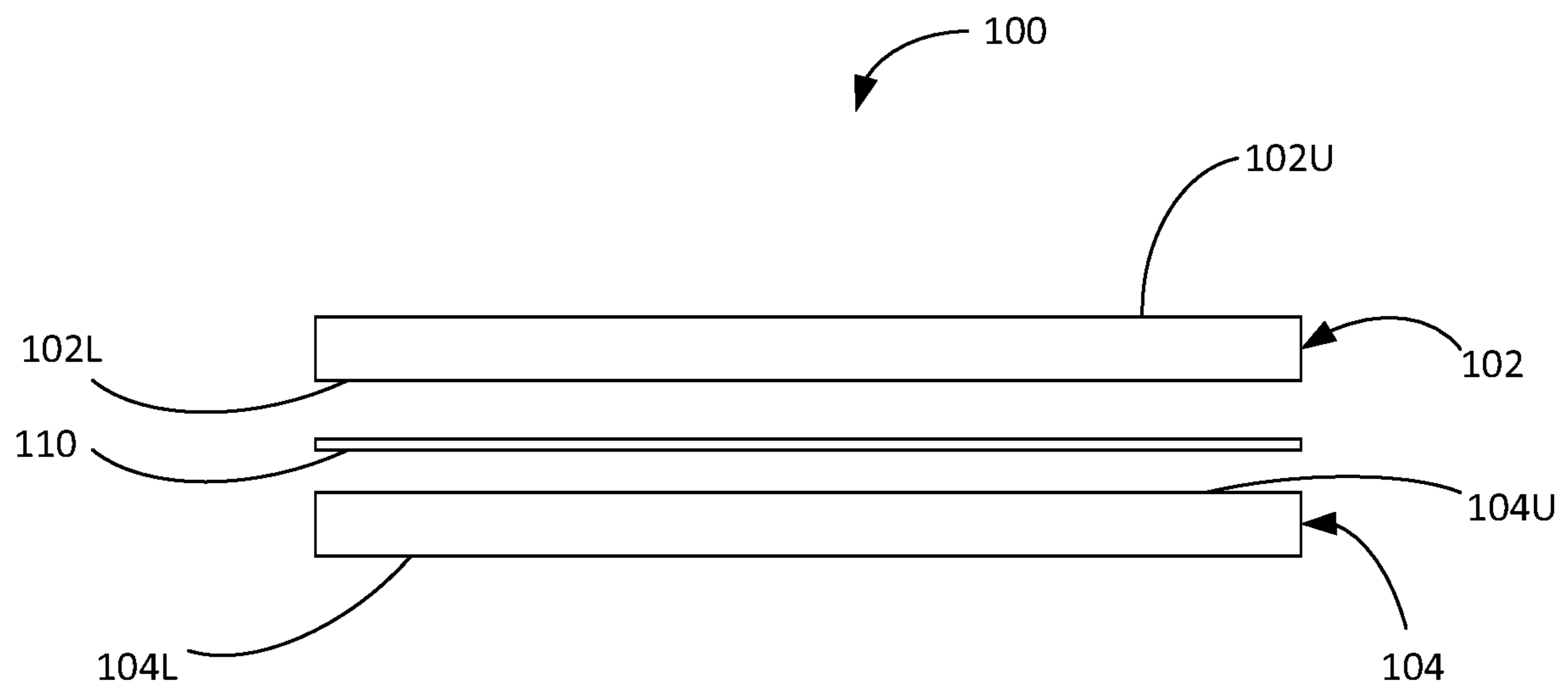


FIGURE 2

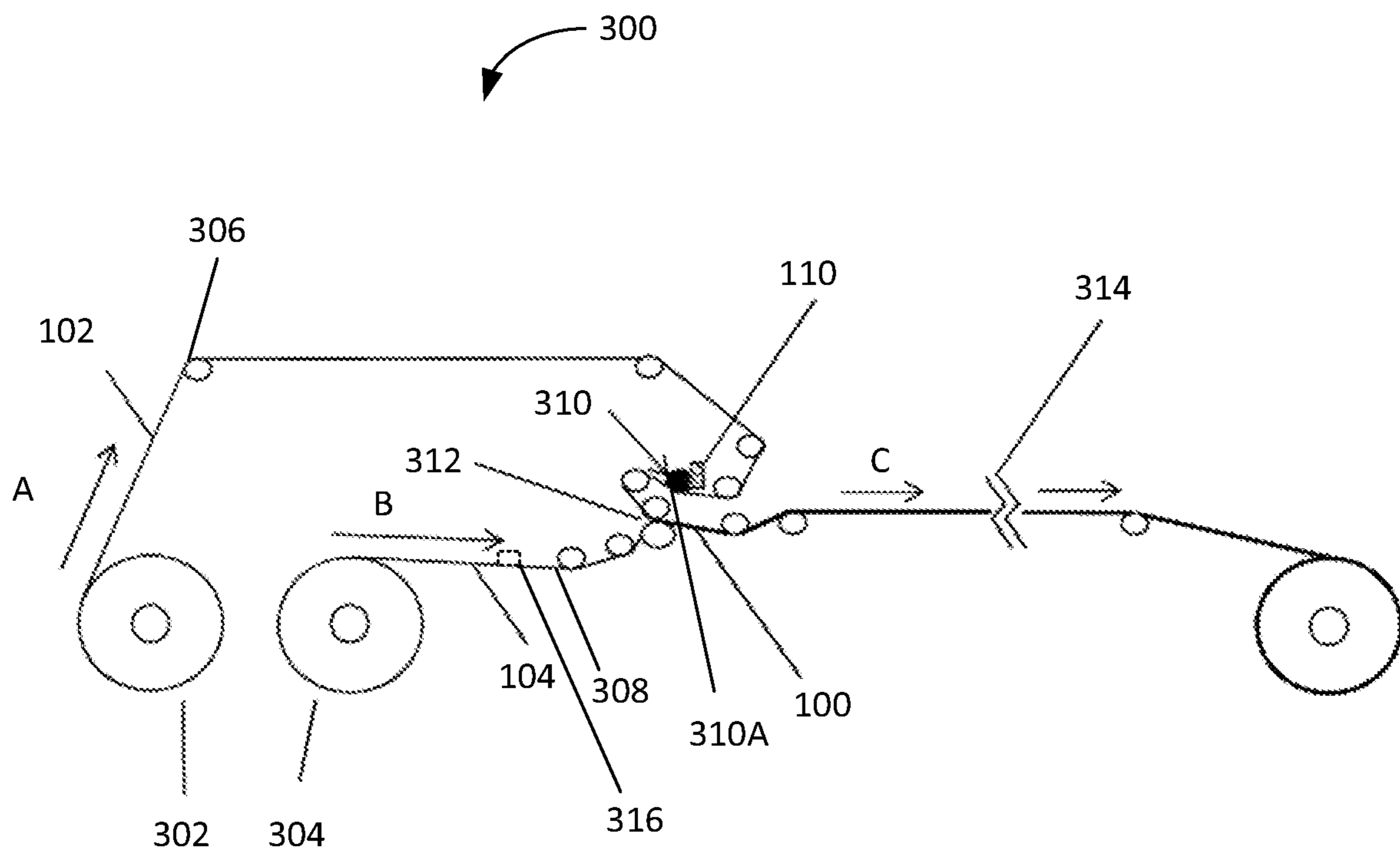


FIGURE 3

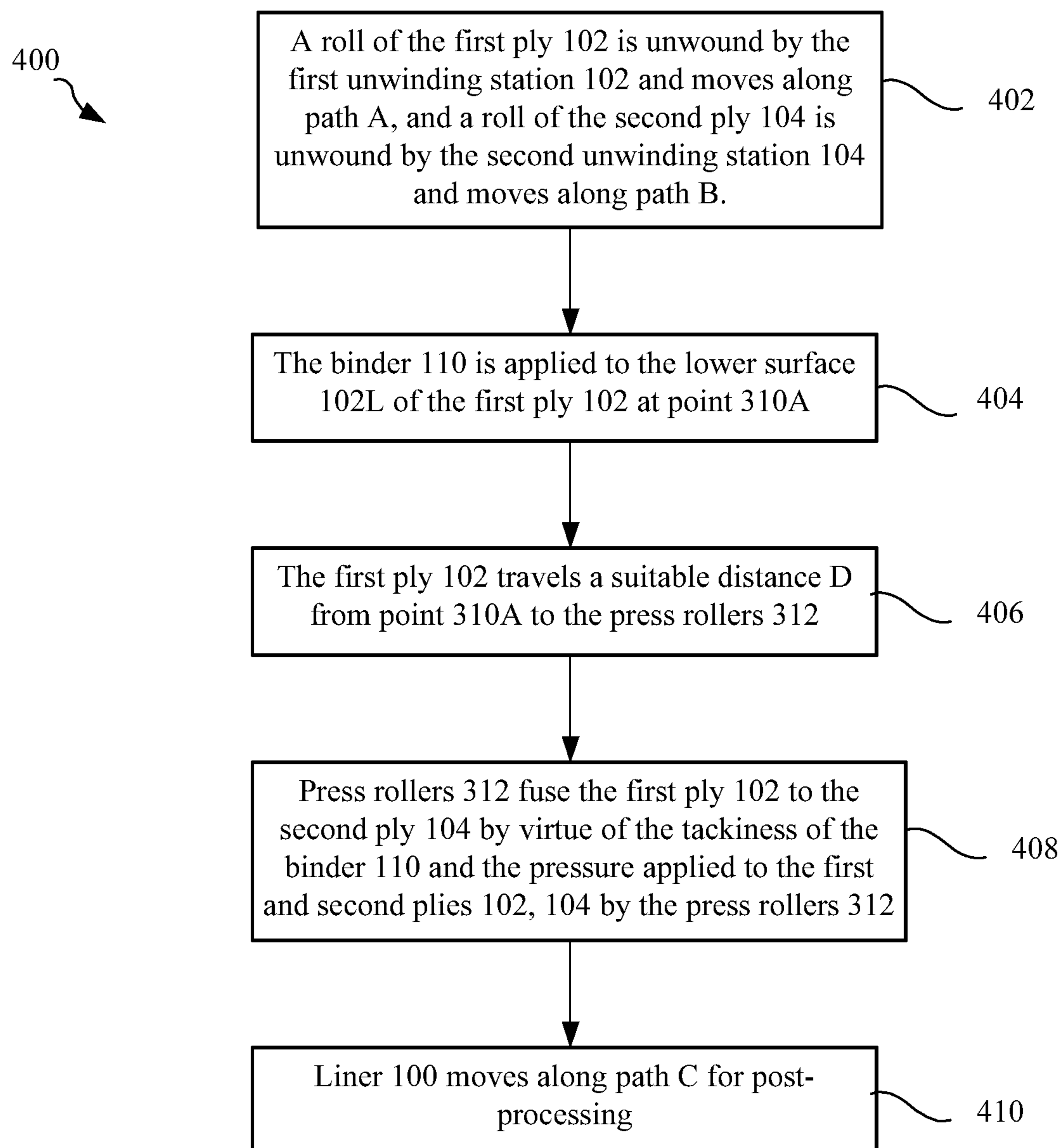


Figure 4

## DUPLEX LINERS AND METHODS OF MAKING AND USING SAME

### CROSS REFERENCE TO RELATED APPLICATIONS

This application is a continuation of U.S. patent application Ser. No. 15/914,647, filed Mar. 7, 2018, to be issued as U.S. Pat. No. 10,882,269, which claims priority to U.S. Provisional Patent Application Ser. No. 62/467,890, filed Mar. 7, 2017, and titled "Duplex Liners." The disclosure of each of the '647 and the '890 Applications is incorporated by reference herein in its entirety.

### FIELD OF THE DISCLOSURE

The disclosure relates generally to the field of liners used in the label industry. More specifically, the disclosure relates to a strong printable duplex liner for use with printable labels and a method of making and using the duplex liner.

### BACKGROUND

A prior art label has a printable ply, referred to by the artisan as face stock, and a liner. The face stock has adhesive on its back face and the adhesive is protected by a liner that is flimsy, weak, and cheap and easy to make. Such conventional liners suffice to cover the adhesive on the face stock prior to use of the label, particularly where the labels are applied by hand. In large warehouses or high-volume shipping companies, however, where automated labeling systems are used to label the packages for storage or shipment, the conventional liners cause problems. For example, the traditional liners may tear or bind up in the automated labeling systems due to their flimsy nature, causing down time and costly production delays.

### SUMMARY

Duplex liners and systems and methods for making and using same are disclosed herein. In an embodiment, a method for making a label comprises providing a printable face ply. The method includes making a duplex liner by: (a) providing a transparent first liner ply; (b) providing a second liner ply that is configured to be printable; and (c) using a binder to bind the first liner ply to the second liner ply. The method includes releasably securing the duplex liner to the printable face ply.

In another embodiment, a method for making a label comprises providing a printable face ply including paper. The method comprises making a duplex liner by: (a) providing a first liner ply comprising plastic; (b) providing a second liner ply comprising paper; and (c) using a binder to bind the first liner ply and the second liner ply. The method comprises releasably securing the duplex liner to the printable face ply.

In yet another embodiment, a method for making a label comprises providing a printable face stock. The method includes making a duplex liner by: (a) providing a first liner ply comprising plastic; (b) providing a second liner ply comprising paper; and (c) using a binder to bind the first liner ply and the second liner ply. The method comprises releasably securing the duplex liner to the printable face stock.

## BRIEF DESCRIPTION OF THE SEVERAL VIEWS OF THE DRAWINGS

Illustrative embodiments of the present disclosure are described in detail below with reference to the attached drawing figures and wherein:

FIG. 1 is a side view of a label having a liner according to an embodiment of the present disclosure;

FIG. 2 is an exploded view of the liner of FIG. 1;

FIG. 3 is a schematic representation of a system for making the liner of FIG. 1, in an embodiment; and

FIG. 4 is a flowchart illustrating a method for making the liner of FIG. 1 using the system of FIG. 3.

### DETAILED DESCRIPTION

Labels, such as shipping labels, pharmaceutical labels, food labels, etc., are ubiquitous. A typical label includes a printable sheet (also referred to as face stock) and a liner. The printable sheet has adhesive disposed on one side thereof. The liner has silicone disposed on one of its sides. The label is formed by releasably adhering the face stock to the liner such that the adhesive on the printable sheet contacts the silicone on the liner. The silicone allows the liner to be removed from the face stock when the label is ready for use.

The face stock of conventional labels may be configured to have a plurality of attributes. For example, and depending on the application, the face stock may be configured to resist peeling off the object to which it is adhered, to resist exposure from heat, to resist exposure from light, to receive machine readable indicia or other indicia, etc. The liner of conventional labels, conversely, is typically configured to perform a solitary task—to cover the adhesive on the associated printable sheet so that the printable sheet may be secured to an object once the liner is removed therefrom. Often, the primary consideration for the manufacture of such disposable liners is cost. Because liners conventionally serve only one purpose, the emphasis is on effectuating this function as cheaply as possible and on nothing more. To this end, the liners of conventional labels are flimsy and made of inexpensive material.

In some applications, it may be desirable to have a liner that is stronger than a traditional liner used in the label industry. It may also be desirable in some applications to have a printable liner. For example, a strong, resilient liner may be advantageous for auto-apply applications (as the traditional liners may tear or bind up in the automated labeling systems due to their flimsy nature). It may likewise be desirable in some applications for the liner to be printable, so that information (e.g., a listing of contents of the package to which the label is adhered, a coupon, a special offer, etc.) may be conveyed to the user. But, the cost of such a strong, printable liner suitable for use in automated labeling systems, if manufactured using conventional processes, may be prohibitive, and indeed, may exceed the cost of the face stock. Such may be undesirable. It may therefore be advantageous to create a liner that is stronger than a conventional liner and is more versatile (e.g., is printable), but which does not add considerably to the cost of making the label as a whole. The present disclosure may, among other things, provide a liner that achieves these and/or other objectives.

FIG. 1 shows a label **10** having a liner **100** made in accordance with an embodiment of the present disclosure. The label **10** may be a shipping label, or another type of label. The label **10** may have a face stock **50** having an upper

surface **50U** and a bottom surface **50B**. The upper surface **50U** may be configured to receive indicia (e.g., may be printable) and the bottom surface **50B** may be provided with adhesive to allow the liner **100** to be releasably coupled thereto, as discussed herein. In embodiments, the face stock **50** may comprise a solitary ply, whereas in other embodiments, the face stock **50** may comprise two or more plies, at least one of which may be configured to receive indicia (e.g., machine readable indicia, printed indicia, handwritten indicia, etc.). As discussed herein, the liner **100** may comprise at least two plies that are fused together. The two plies may allow the liner **100** to be more resilient as compared to traditional liners, and further, may advantageously allow the liner **100** to receive printed or other indicia.

FIG. 2 shows an exploded view of the liner **100** of FIG. 1. The liner **100** may also be referred to herein as a “duplex liner.” As noted, however, in embodiments, the liner **100** may have more than two plies.

The illustrated liner **100** comprises a first (or a top) ply **102** and a second (or a bottom) ply **104**. The first ply **102** has an upper surface **102U** and a lower surface **102L**. The second ply **104** likewise has an upper surface **104U** and a lower surface **104L**.

In an embodiment, the first ply **102** may be or may comprise a polyester (or other plastic) sheet. Alternately, the first ply **102** may comprise a sheet made of another suitable material (e.g., another polymer) that allows the first ply **102** to be more resilient as compared to the second ply **104**. That is, the first ply **102** may, in embodiments, be relatively rigid as compared to the second ply **104** (and traditional liners). The polyester sheet **102** may, in embodiments, be transparent or generally transparent.

The first ply **102**, on its upper surface **102U**, may be provided with a release material, such as silicone and/or another release material (e.g., a nonstick coating). The upper surface **102U** may thereafter be placed in contact with the bottom surface **50B** of the face stock **50**, and more particularly, with the adhesive situated thereon. Such may cause the first ply **102** of the liner **100** (together with the second ply **104** thereof, as discussed herein) to releasably adhere to the bottom side **50B** of the face stock **50** to form the label **10**.

The second ply **104** of the liner **100** may comprise paper and/or typical release liner material. The second ply **104** may in embodiments be opaque or generally opaque, and in other embodiments, may be translucent. In embodiments, the second ply **104** may be configured to be printable (e.g., may be configured to receive printed and/or handwritten indicia). For example, the second ply **104** may be configured to be printed with a direct thermal printer, a thermal printer, a laser printer, or another printer. The artisan will understand that the material for the second ply **104** (and the other parts forming the duplex liner **100**) may be chosen in line with the requirements of a particular application. For instance, if the application would benefit from a printable liner that is durable, a relatively higher quality printable second ply **104** may be employed in the liner **100**.

The first ply **102** and the second ply **104** may, in an embodiment, be fused together with a binder (or bonding agent) **110**. The fusing of the first ply **102** and the second ply **104** via the binder **110** may increase the resilience of the liner **100** as compared to typical prior art liners. Moreover, because the second ply **104** may be printable and the liner **100** may be relatively resilient at least in part because of the first ply **102** thereof, the liner **100** may be more versatile than prior art liners.

The binder **110** may, in embodiments, comprise synthetic latex. For example, the binder **110** may be a copolymerized

emulsion, such as an emulsion comprising Styrene, Butadiene, and Acrylic monomer. In an embodiment, the binder **110** may be commercially available, and may include, e.g., HITEX S-209 or another binder. In another embodiment, a different binder (e.g., a suitable adhesive) may be used to fuse the first ply **102** and the second ply **104**. In some embodiments, and as discussed herein, indicia may be printed on the lower surface **104L** of the second ply **104**. Alternately or additionally, in embodiments, the upper surface **104U** of the second ply **104** may be configured to be printable. Where the upper surface **104U** of the second ply **104** is printable, care may be taken to ensure that the binder **110** is chosen such that it does not adversely interact with the printable coating (e.g., the direct thermal coating) or the printed indicia on the upper surface **104U** of the second ply **104**.

FIG. 3 schematically represents a system **300** for making the liner **100**, in an embodiment. The artisan will understand that the system **300** and the various components thereof as described herein are merely exemplary and that the figure is not intended to be independently limiting. The system **300** may also be referred to herein as a printing press **300**.

The system **300** may, in an embodiment, comprise a first (or left) unwinding station **302** and a second (or right) unwinding station **304**. One of the unwinding stations may be associated with the first ply **102** and the other unwinding station may be associated with the second ply **104**. For example, the left unwinding station **302** may be associated with the first ply **102** and the right unwinding station **304** may be associated with the second ply **104**. The first and the second unwinding stations **302** and **304** may respectively unwind rolls of the first ply **102** and the second ply **104** to allow the system **300** to form liners **100** therefrom, as discussed herein. The system **300** may comprise one or more rollers, e.g., roller **306** and **308** and other rollers, to allow the first ply **102** and the second ply **104** (and more specifically, a sheet comprising a plurality of first plies **102** and a sheet comprising a plurality of second plies **104**) to move through the system **300** as desired to form the liners **100**.

The first ply **102** (and more particularly, a sheet comprising a plurality of first plies **102**) may travel along the path A and eventually come into contact with a flood coat roller **310**. The flood coat roller **310** may be configured to aid in the application of the binder **110** to the first ply **102**, and more specifically, to the lower surface **102L** thereof. In an embodiment, the coating of the binder **110** applied to the first ply **102** may be about 10 BCM. Alternately, another suitable amount of the binder **110** may be applied to the lower surface **102L** of the first ply **102**. In an alternate embodiment, a different configuration of rollers may be used to facilitate the application of the binder **110** to the first ply **102** (e.g., embodiments where the first ply **102** passes between an analog roller and a flex roller that rotate in opposite directions and are driven by an impression (e.g., an anvil) roller are also contemplated).

The system **300** may comprise two complementary press rollers **312**. The press rollers **312** may be configured to apply pressure to the two (or more) plies passing therethrough such that they are pressed together. Once the first ply **102** has the binder **110** applied to the lower surface **102L** thereof, it may travel to the press rollers **312**, where it may meet the second ply **104**, and specifically, come adjacent and contact the upper surface **104U** thereof. The press rollers **312** may press the first ply **102** against the second ply **104**. This pressure applied by the press rollers **312**, together with the tackiness of the binder **110**, may cause the first ply **102** (and

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specifically, the lower surface 102L thereof) to fuse with the second ply 104 (and specifically, the upper surface 104U thereof).

Care may be taken to ensure that the first ply 102, once the binder 110 has been disposed on the underside 102L thereof, comes into contact with the second ply 104 so as to allow the binder 110 to fuse the first ply 102 to the second ply 104. Specifically, once the binder 110 is applied to the lower surface 102L of the first ply 102, the first ply 102 may become soggy for a time period until the binder 110 has had the opportunity to dry at least in part. Thus, if the binder 110 is applied to the lower surface 102L of the first ply 102 and then the first ply 102 is immediately brought into contact with the second ply 104 at the press roller 312, the first ply 102 may be unduly wet and therefore may not properly fuse with the second ply 104. Alternately, if an unduly long delay exists between the application of the binder 110 to the first ply and the meeting of the first ply 102 and the second ply 104 in the press rollers 312, the binder 110 may become too dry and may become unworkable to suitably fuse the first ply 102 to the second ply 104. Experimentation has shown that if the first ply 102 is running at about a 100 feet a minute along path A, the distance between a point 310A at which the binder 110 is applied to the first ply 102 and the press rollers 312 (i.e., a “wet distance”) may be about 12 inches to 14 inches. Such a wet distance of about 12 inches to 14 inches (when the first ply is running at about a 100 feet a minute) may give the binder 110 time to suitably dry (and not over-dry) to allow the first ply 102 to be fused to the second ply 104. Of course, if the first ply 102 is running at about 200 feet a minute along path A, the distance between the point 310A at which the binder 110 is applied to the first ply 102 and the press rollers 312 may be doubled to between 24 inches to 28 inches. Likewise, if the first ply 102 is running at about 50 feet a minute on path A, the wet distance may be decreased to between 6 inches and 7 inches. And so on.

The duplex liner 100 (and more particularly, a sheet comprising a plurality of duplex liners 100) may then go downstream the press rollers 312 along path C for post-processing. The post-processing is schematically illustrated in FIG. 3 at point 314. The post-processing may include, e.g., die cutting the fused sheet comprising the plurality of liners 100 to create individual liners 100. The post-processing may also include printing, fan folding, adding perforations, and other such post-processing steps that may allow the liners 100 to be used as desired. For example, in an embodiment, the liner 100 may be provided with a perforated border inwardly adjacent the outer edges thereof; in these embodiments, adhesive may be provided outwardly adjacent the perforated border to allow the liner 100 to adhere to the face stock 50 and printed indicia may be provided inwardly adjacent the perforated border to allow the printed section to be separated from the remainder of the liner 100 after the liner 100 is separated from the face stock 50.

In an embodiment, and particularly where the upper surface 104U of the second ply 104 is configured to be printable, the system 300 may optionally comprise a printing station 316 along path B upstream of the press rollers 312 where the first ply 102 is fused with the bottom ply 104. The printing station 316 may be configured to print indicia on the upper surface 104U of the second ply 104. As noted, the first ply 102 may in embodiments comprise clear poly material. The clear poly material of the first ply 102 may allow the indicia printed on the upper surface 104U of the second ply 104 to be viewed therethrough after the bonding of the first ply 102 and the second ply 104, thereby adding to the

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versatility of the duplex liner 100. As noted, in these embodiments, care may be taken to ensure that the binder 110 does not adversely interact with the printable coating and/or the printed indicia on the upper surface 104U of the second ply 104. Alternately or additionally, a printing station may be provided downstream of the press rollers 312 and/or a user downstream of the label manufacturer (e.g., a retailer) may print indicia on the lower surface 104L of the second ply 104 prior to adhering the label 10 to an object.

FIG. 4 shows a method 400 for making the liner 100, in an embodiment. At step 402, a roll of the first ply 102 may be unwound by the first unwinding station 302 and move along path A, and a roll of the second ply 104 may be unwound by the second unwinding station 304 and move along path B.

At step 404, and with the aid of the flood coat roller 310 (or via other means), the binder 110 may be applied to the lower surface 102L of the first ply 102 at point 310A.

At step 406, after the binder 110 is applied to the lower surface 102L of the first ply 102, the first ply 102 may travel a suitable distance D to the press rollers 312. As noted, the suitable distance D may depend on the speed at which the first ply is traveling at path A. For example, if the first ply 102 is traveling at path A at about 100 feet a minute, the distance D between the point 310A at which the binder 110 is applied to the first ply 102 and the press rollers 312 may be about 12 inches to 14 inches.

At step 408, the first ply 102 may meet the second ply 104 at the press rollers 312, and the pressure applied by the press rollers 312, together with the tackiness of the binder 110, may cause the first ply 102 to fuse with the second ply 104. As noted, in embodiments, indicia may be printed on the upper surface 104U of the second ply 104 before the second ply 104 is fused with the first ply at the press rollers 312.

At step 410, the liner 100 (and specifically a sheet comprising a plurality of liners 100) may move downstream of the press rollers 312 along path C for post-processing, e.g., die-cutting, printing, etc.

Thus, as has been described, the liner 100 may be stronger than typical liners used in the label industry, may be adaptable to a particular application, and unlike other premium liners which may be stiff and bulky, may be thin and flexible. Importantly, the cost of manufacturing the liner 100, in embodiments, may be a fraction of the cost of manufacturing other premium liners.

Many different arrangements of the various components depicted, as well as components not shown, are possible without departing from the spirit and scope of the present disclosure. Embodiments of the present disclosure have been described with the intent to be illustrative rather than restrictive. Alternative embodiments will become apparent to those skilled in the art that do not depart from its scope. A skilled artisan may develop alternative means of implementing the aforementioned improvements without departing from the scope of the present disclosure.

It will be understood that certain features and subcombinations are of utility and may be employed without reference to other features and subcombinations and are contemplated within the scope of the claims. Not all steps listed in the various figures need be carried out in the specific order described.

The invention claimed is:

1. A method for making a label, comprising:
  - providing a printable face ply having a face ply upper side and an opposing face ply lower side;
  - making a duplex liner by: (a) providing a first liner ply having a first liner ply upper side and an opposing first liner



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ply lower side, said first liner ply being transparent; (b) providing a second liner ply having a second liner ply upper side that is configured to be printable, said second liner ply upper side opposing a second liner ply lower side; and (c) using a binder to bind said first liner ply lower side to said second liner ply upper side; and  
 releasably securing said duplex liner to said printable face ply lower side.

2. The method of claim 1, wherein said second liner ply comprises paper.

3. The method of claim 2, wherein said first liner ply is a plastic sheet.

4. The method of claim 3, further comprising printing indicia on said second liner ply upper side such that said printed indicia is viewable through said plastic sheet.

5. The method of claim 4, wherein said binder comprises a copolymerized emulsion.

6. The method of claim 1, further comprising using press rollers in binding said first liner ply to said second liner ply.

7. The method of claim 1, wherein each of said second liner ply upper side and said second liner ply lower side is configured to be printable.

8. The method of claim 1, wherein each of said first liner ply and said second liner ply are part of respective first and second rolls, and wherein said duplex liner is disassociated from each of said first and second rolls after said first liner ply and said second liner ply are bound to each other.

9. The method of claim 1, further comprising printing indicia on said second liner ply such that said printed indicia is adjacent said first liner ply.

10. The method of claim 1, further comprising printing said indicia on said second liner ply prior to binding said first liner ply and said second liner ply.

11. The method of claim 1, wherein said first liner ply comprises at least one polymer.

12. The method of claim 1, wherein said first liner ply comprises a release agent and said printable face ply comprises an adhesive.

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13. A method for making a label, comprising:  
 providing a printable face ply comprising paper, said face ply having a face ply upper side and an opposing face ply lower side;

5 making a duplex liner by: (a) providing a first liner ply comprising plastic, said first liner ply having a first liner ply upper side and an opposing first liner ply lower side; (b) providing a second liner ply comprising printable paper, said second liner ply having a second liner ply upper side and an opposing second liner ply lower side; and (c) using a binder to bind said first liner ply lower side to said second liner ply upper side; and  
 releasably securing said duplex liner to said printable face ply lower side.

14. The method of claim 13, wherein said first liner ply is transparent.

15 15. The method of claim 13, further comprising printing indicia on said second liner ply upper side such that said printed indicia is viewable through said first liner ply.

16. The method of claim 13, wherein said binder comprises a copolymerized emulsion.

17. The method of claim 13, further comprising using press rollers in binding said first liner ply to said second liner ply.

18. A method for making a label, comprising:  
 providing a printable face stock, said face stock having a face stock upper side and an opposing face stock lower side, said face stock lower side having an adhesive layer;

25 making a duplex liner by: (a) providing a first liner ply comprising plastic; (b) providing a second liner ply comprising printable paper; and (c) using a binder to bind said first liner ply and said second liner ply; and  
 releasably securing said duplex liner to said printable face stock via said adhesive layer on said face stock lower side.

19. The method of claim 18 further comprising using  
 30 35 press rollers to bind said first liner ply to said second liner ply.

20. The method of claim 19, further comprising printing indicia on said second liner ply prior to binding said second liner ply to said first liner ply.

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